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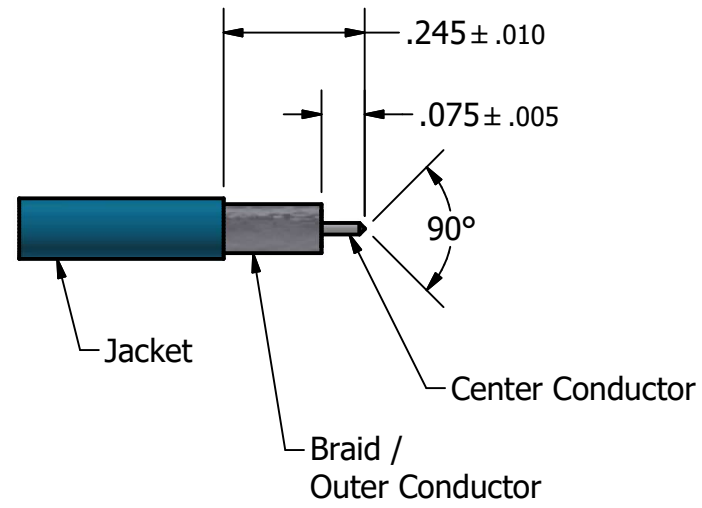
Step 1 (PER CABLE TYPE)

*FOR FLEX CABLES: (Jacketed)

- Flux and Tin Dip Cable to dimension: $.270 \pm .010$
- Trim Jacket to dimension: $.245 \pm .010$
- Trim Center Conductor to dimension: $.075 \pm .005$

*FOR SEMI RIGID CABLES: (Non-Jacketed)

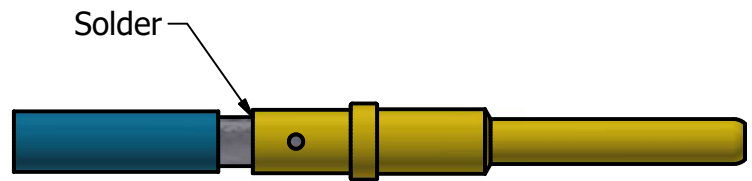
- Trim Center Conductor to dimension: $.075 \pm .005$



Point Center Conductor

Step 2

Insert cable into PkZ[®] assembly until cable bottoms and solder as shown.
Clean solder joint.



WARNING - THIS DOCUMENT CONTAINS TECHNICAL DATA WHOSE EXPORT IS RESTRICTED BY THE ARMS EXPORT CONTROL ACT (TITLE 22, U.S.C., SEC 2751, ET. SEQ.) OR THE EXPORT ADMINISTRATION ACT OF 1979, AS AMENDED, TITLE 50, U.S.C., APP 2401 ET SEQ. VIOLATIONS OF THESE EXPORT LAWS ARE SUBJECT TO SEVERE CRIMINAL PENALTIES. DISSEMINATE IN ACCORDANCE WITH PROVISIONS OF DOD DIRECTIVE 5230.25.

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MATERIAL:

UNLESS OTHERWISE SPECIFIED, PHOENIX WORKMANSHIP STANDARDS APPLY. DIMENSIONS IN INCHES OR (METRIC). DO NOT SCALE PRINTS						APPROVALS		DATE			
						DRAWN		RA		4/9/2024	
TOLERANCES ARE: FRACTIONS: $\pm 1/64$ DECIMALS: $.XX \pm .01$.XXX $\pm .003$ ANGLES: $\pm 1/2^\circ$						CHECKED		SPS		4/9/2024	
						QA		MFG			
						ENGINEER		SPS		4/9/2024	
						APPROVED		SPS		4/9/2024	
REV. DESCRIPTION BY DATE APPR. DATE											
A	PER ECN 14385	RA	4/9/2024	SPS	4/9/2024						

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TITLE

CABLE ASSEMBLY PROCEDURE FOR 268L-0021-0860

SIZE	FSCM	DWG NO	REV	PLATING OPT.
A	58167	268L-0021-0860	A	
SCALE	F.S.R. #		SHEET 1 OF 1	

2

1